ork Order ID	71032
uesday, June 21, 2011	10:36:34 AM



Page 1

Item ID: D3197-041 Accept Setup Start **Revision ID:** Stop Item Name: Bar Assembly **Start Date:** 6/21/2011 Start Qty: 6.00 **Cust Item ID:** Required Date: 6/27/2011 Req'd Qty: 6.00 **Customer:** Reference: Run Start Process Plan: Date://-04-21 Approvals: **Tooling:** Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation 5 Set Up/ Tool ID Plan Tool#' Reject Accept Reject Insp. **Work Center ID Description Run Hours** Code Qty Number Stamp Qty Draw Nbr Revision Nbr D3197 Rev B 100 0.00 **BAND SAW** Bandsaw 0.00 Memo Jeaspa Bandsaw Cut blanks: 29.125" long 0.00 HAAS CNC VERTICAL MACHINING # 0.00 HAAS CNC vertical machine #1 1-Face ends to lenght per dwg D3197 - 2-Machine D3197-1 as per Folio FA340 and Dwg D3197 □3-Deburr 120 QC2- Inspect parts off machine FAI/FAIB 0.00 14. QC 0.00 Memo Quality Control

Dart Aeros	pace Ltd
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W/O:			WC	RK ORDER CHANG	ES				·
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	\:	_ Date: _	
		solution:							
NCR:		<u> </u>	WORK ORDE	ER NON-CONFORMA	NCE (NCR	)			· · · · · · · · · · · · · · · · · · ·
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approva
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspecto
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#### Work Order ID 71032

Tuesday, June 21, 2011 10:36:34 AM



Page 2

Item ID:

D3197-041

Accept

Setup Start



**Revision ID:** 

Item Name:

Bar Assembly

**Start Date:** 

6/21/2011

Start Qty: 6.00

Required Date: 6/27/2011

Req'd Qty: 6.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

**Tooling:** 

Date:

Run

Start

Stop

Stop



QC:

Date:

SPC (Y/N):

Date: Tool ID

Tool # Plan

Accept Qty

Reject **Qty** 

Reject Insp. Number Stamp

Work Center ID 130

Sequence ID/

Lathe Conv

Conventional Lathe

Operation Description

CONVENTIONAL LATHE

Memo

Chamfer as per Dwg D3197

Set Up/ Run Hours

0.00

0.00

D.A 11/07/13

Code

140

Quality Control

QC8- Inspect parts - second check

Memo

0.00 11-67-25

0.00

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

6 p 14 4/03/22

W/O:			WC	ORK ORDER CHANG	GES					
DATE	STEP	PRO	CEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Cate	gory:	NCF	R: Yes	No <b>DQ</b>	A:	_ Date: _	
	R	esolution:	Disposition	n:	QA:	N/C Cld	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	IANCE	(NCR	)			
DATE	STEP	Description of NC		<u> </u>	ction B		Verific	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
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#### Work Order ID 71032

Tuesday, June 21, 2011 10:36:34 AM



Page 3

Item ID:

D3197-041

Accept

Setup Start



**Revision ID:** 

**Start Date:** 

Item Name: Bar Assembly

6/21/2011

Start Oty: 6.00

Required Date: 6/27/2011

Req'd Qty: 6.00



Date:

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

QC:

Date:

Tooling:

Date:

Date:

Start

Stop

Stop

Sequence ID/ **Work Center ID** 

160

Powdercoat

Powder Coating

Operation Description

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Set Up/ **Run Hours** 

SPC (Y/N):

0.00

Tool ID

Tool # Plan

Code

Accept Qty

Reject **Qty** 

Run

Reject Insp. Number Stamp

6 6 Kh 11-7-8

Memo

Memo

M 117338

☐FINISH TIME:

0.00

OVEN TEMPERATURE:

170

Quality Control

QC3- Inspect Part Finish

0.00

0.00

180

Small Fab Small Fab

Small Fab

Memo

0.00

0.00

Assemble D3197-041 as per Dwg D3197

511/08/09

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W/O:			W	ORK ORDER CHAN	IGES			-		· · · · · · · · · · · · · · · · · · ·
DATE	STEP	PRO	CEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCI	R: Yes	No <b>DQ</b>	A:	_ Date: _	
		esolution:								
NCR:			WORK ORD	ER NON-CONFORI	MANCE	(NCR	)			
DATE	STEP	Description of NC			ection B		Verific	cation	Approval	Approval
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#### Work Order ID 71032

Tuesday, June 21, 2011 10:36:34 AM



Page 4

Item ID:

D3197-041

Accept

Setup Start



**Revision ID:** 

Item Name:

Bar Assembly

**Start Date:** 

6/21/2011

Start Qty: 6.00

**Req'd Qty:** 6.00

Memo

Memo



Date: \_\_\_\_\_

Cust Item ID:

**Customer:** 

Reference:

Approvals:

Required Date: 6/27/2011

Process Plan: \_\_\_\_\_ Date:

Tooling: SPC (Y/N):

Date:

Date:

Run

Start

Stop

Stop



Sequence ID/ **Work Center ID** 

190

QC

Quality Control

Operation **Description** 

QC5- Inspect part completeness to step on W/O

Set Up/

**Run Hours** 

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

200

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

0.00

0.00

210

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng / QC ins  Part No: PAR #: Fault Category: NCR: Yes No DQA: Date:  Resolution: Disposition: QA: N/C Closed: Date:  NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC Corrective Action Section B Verification Approval Approva											
Part No:PAR #: Fault Category: NCR: Yes No DQA: Date:  Resolution: Disposition: QA: N/C Closed: Date:  NCR: VORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC Section A	W/O:			V	ORK ORDER CHANG	ES					
Resolution:	DATE	STEP	Р	ROCEDURE CH	IANGE	Ву		Date	Qty	Chief Eng /	Approval QC Inspector
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Resolution:											
NCR:    DATE   STEP   Description of NC   Section A   Chief Eng	Part No	:	PAR #:	Fault Ca	tegory:	NCR: Y	es N	o <b>DQ</b>	A:	Date: _	
DATE STEP Description of NC Section A Description of NC Section A Date Description Chief Eng Chi		R	esolution:	Disposit	ion:	_ QA: N/C	Clos	ed:		Date: _	
DATE STEP Description of NC Section A Section A Section C Section	NCR:			WORK OR	DER NON-CONFORMA	NCE (N	CR)				
Section A Chief Eng Chief	DATE	STEP		Initial			ın &				Approval
			Section A		Chief Eng			Secti	ion C	Chief Eng	QC Inspector
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## **Picklist Print**

Tuesday, June 21, 2011 10:36:41 AM

Work Order ID: 71032

Parent Item: D3197-041

Parent Item Name: Bar Assembly



Start Date: 6/21/2011

Start Qty: 6.00

Required Date: 6/27/2011

Page 1

Required Qty: 6.00

Comments:

IPP Rev: A New Issue 05-11-08 JLM IPP Rev:B As per Rev B 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS27039-1-24	79.1 11.1 11.1 11.1 11.1 11.1 11.1 11.1	Purchased	No			100	Each	110.0000	2	12/5/1	/08/	109	
				Location ST292	100151	Loc	<u>Oty</u> 110 110	Loc Code	_	D	-	١	
AN960JD10 	NAS1149D0363J		O I	364		180	Each	0.0000		36/1	/08/	109	
D2690-5		Manufactured	No			180	Each	31.0000		12/15/11/	/08/	69	
				Location ST020	70390	Loc	Oty 31 31	Loc Code		12	- -	े <i>क्</i> रे	
D3242-1 		Manufactured	No		70390	180	Each	4.0000	2	12	- [1] [0	8/0,	, 9
				<u>Location</u> GA	70154	Loc	<u>Otv</u> 4 4	Loc Code	-		B	7/17	66
D3489-3-200 PIP PIN		Manufactured	No			180	Each	12.0000		13/4	/08/1	99	
				Location ST062	<b>1</b> 70271	Loc	Oty 12 12	Loc Code	- -	9	- -	BZ	(17)

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DO	QA:	_ Date: _	
	R	esolution:	Disposit	ion:	QA: N/C	Closed: _		Date: _	
NCR:	-	V	VORK OR	DER NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Sect		Verif	ication	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		ction C	Chief Eng	QC Inspector
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Picklist Print							-
Tuesday, June 21, 2011 10:36:41 AM							
Work Order ID: 71032							
Parent Item: D3197-041	• • • • • • • • • • • • • • • • • • • •						
Parent Item Name: Bar Assembly	( )Běilie i		1881 1181 1881		Sta	art Date: 6/2	1/2011
					St	art <b>Qty:</b> 6.0	0
M7075T73R1.000 Purchased	No		180	f	12.7150	2.42	18.15
		Location	Lo	c Oty	Loc Code		
	25 <sup>f†</sup>	MAT012		12.715			

					1	
<b>Location</b>	Loc Oty	Loc Code				
MAT012	12.715					
115165	2.7				•	
116405	4.54					
116604	2.25					
116835	2.32					
116962	0.905					
	180 E	ach 2,077.000	2	12	, /	
		1				

MS21042L3 Nut

Purchased

No

**Location** Loc Qty ST300 2077 116549 377 117441 800 117601 400 117885 500 Loc Code

Page 2

Required Date: 6/27/2011 Required Qty: 6.00

W/O:			W	ORK ORDER CHANGI	ES		.,		
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	Date: _	
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NCR:		\	WORK ORE	DER NON-CONFORMA	NCE (NCR	)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DAIL	012.	Section A	initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
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		*:							

DART AEROSPACE LTD	Work Order:	71032
Description: Bar	Part Number:	D3197-1
Inspection Dwg: D3197 Rev: B		Page 1 of 1

#### FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29.000	<b>J</b>		Tape	GA-12
25.06	+/-0.030	25.060	✓ ·		ii	11
11.44	+/-0.030	11.445	<b>J</b>		Vern	CNC-02
0.500	+/-0.010	0.500	~		VERN	GA-01
0.250	+/-0.030	0.257			17	1)
Ø0.219	+0.005/-0.000	\$0.226	~		11	Ŋ
Ø0.191	+0.005/-0.000	Ø 0.193	<b>√</b>		H	1/
1.000	+/-0.005	1.000	✓ ·		Ħ	1)
2.69	+/-0.030	2.688	1		11	ıl
1.000	+/-0.010	1.000	/		k	n
0.300	+/-0.010	0.302	~		V	11
0.063 x 45°	+/-0.010	0.064 x45°	<b>✓</b>		11	11
Ø1.000	+/-0.010	\$1.000	<u> </u>		ļl	11

Measured by: H.A	Audited by:	Prototype Approval:	N/A
Date: N 07 22	Date: \	1-04-25 Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	04.04.20	New Issue	(P/O D3197-041)	KJ/JLM 1.A	
В	07.03.09	Dwg revision up	date	KJ/JLM 🚓	B

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W/O:			WC	RK ORDER CHANGES		<del></del>	·		
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
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Part No	:	PAR #:	Fault Cateo	jory: l	NCR: Yes	No DQ	A:	_ Date: _	
Resolution:			Disposition	QA: N/C Closed:			Date: _		
NCR:		\	WORK ORDE	R NON-CONFORMAN	CE (NCR	1)		-	
		Description of NC		Corrective Action Section B	3	Verific	eation	Approval	Approval
W/O: DATE Part No:	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section C		Chief Eng	QC inspector
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		PAR #: Fault Category:							
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ESS CONDITION THAT IT IS
WRITTEN PERMISSION FROM AEROSPACE 달중 ₽ PURPOSE ဝွ

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Dart Aeı	rospace	Prod Mgr OC Inspector  Prod Mgr OC Inspector  Prod Mgr OC Inspector  NCR: Yes No DQA: Date:  Resolution: Disposition: QA: N/C Closed: Date:  WORK ORDER NON-CONFORMANCE (NCR)										
W/O:	1				WORK	ORDER	CHANGES				<b>3</b>	
DATE	STEP			PROCE	DURE CHANGE			Ву	Date	Qty	Chief Eng /	Approval QC Inspector
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Part No	:		PAR	#:	Fault Category:		NC	R: Yes	No DQ	A:	_ Date: _	· ·
	· R	Resolution			Disposition:		QA	: N/C C	closed:	*	Date: _	•
NCR:		,		WC	ORK ORDER N	ION-CON	IFORMANCE	E (NC	R)			

NCR:			WORK ORD	DER NON-CONF	ORMANCE	(NCR)			
DATE		Description of NC		<b>Corrective Action</b>	Section B		Verification		Ammerical
	STEP	Section A	Initial Chief Eng	Action Descr Chief Eng		Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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